

CLAIMS

What is claimed is:

1. A method of laminating comprising:
 - providing a plurality of layers to be laminated;
 - determining the thermal coefficient of expansion (TCE) of the plurality of layers;
 - providing an alignment plate having approximately the same TCE; and
 - stacking the plurality of layers onto the alignment plate.
2. The method of claim 1 further wherein the alignment plate comprises tooling pins; the method further comprises drilling registration holes in the layers to be laminated, the registration holes having a diameter at least as large as the diameter of the tooling pins of the alignment plate; and the step of stacking the plurality of layers onto the alignment plate comprises forcing the tooling pins through the registration holes of each layer of the plurality of layers.
3. The method of claim 2 wherein the tooling pins comprise a conical tip and the method further comprises the step of resting each layer of the plurality of layers on the tips of the tooling pins prior to forcing the tooling pins through the registration holes of each layer.
4. The method of claim 3 wherein the diameter of the registration holes is 0-5 μ m smaller than the diameter of the tooling pins.
5. The method of claim 4 wherein the step of providing the plurality of layers comprises providing a plurality of layers, each layer of the plurality of layers having a TCE substantially similar to the TCE of each of the other layers of the plurality of layers.
6. The method of claim 5 wherein the greatest difference in TCE between any two layers is less than 2 ppm.

7. The method of claim 6 wherein the difference in TCE between the alignment plate and the average of the TCEs of the layers is less than 2 ppm.